

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011459**Date Inspected:** 03-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China

<b>CWI Name:</b>	Mr.Li Yang / Mr.Wuzhi Cheng			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	OBG		

**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

**TRIAL ASSEMBLY AREA**

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) of weld joint OBE6C-003 located on 6AE-6BE. Welder is identified as 220063. ZPMC Certified Welding Inspector (CWI) is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS: B-T-2233T.

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) of weld joint OBW6C-003 located on 6CW. Welder is identified as 220066. ZPMC Quality Control (QC) is identified as Fang Ya Jun. The welding variables recorded by QC appeared to comply with WPS: B-T-2233T.

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) repair of weld joint 128 located on SEG023E. Welder is identified as 066261. ZPMC Quality Control (QC) is identified as Wang Li Yang. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G (4F)-Repair and WRR No is: B-WR9498.

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## WELDING INSPECTION REPORT

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This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) Repair of weld joint located on 6AE Strut plate X3S&X8E(Between PP-38 &PP-39).Welding Repair Report No is:WRR-B-WR9540. Welder is identified as 044779. ZPMC Quality Control (QC) is identified as Wang Xiang Pin. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW3G (3F) Repair-FCM.

This QA Inspector observed the Magnetic Particle Testing(MT) has been performed by ZPMC MT Technician Mr. Ting A Chong for Deck plate weld joint between 5BE TO 5CE.This QA witnessed the job randomly.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prabhu,Surendra	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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